

Work Order ID 78964

January-17-12 2:55:29 PM

shy feb. 3
78964

Page 1

Item ID: D3536-13

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gasket

Start Date: 17/01/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 24/01/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: *MLJ*

Date: *12/01/12*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 Dwg Rev: *A* Prog Rev: *A* 2-
Deburr if necessary

B12-2-1

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-2-1

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5/2/12

conf
724

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78964

78964

Page 2

January-17-12 2:55:29 PM

Item ID: D3536-13

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: - Gasket

Start Date: 17/01/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 24/01/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: FP

0.00

130

Packaging

Memo

0.00

Packaging

12/2/12 50 (20)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

M.C.J 12/02/103 (24)

12/20/12 (24)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January-17-12 2:55:33 PM

Page 1
3

Work Order ID: 78964

78964

Parent Item: D3536-13

D3536-13

Parent Item Name: Gasket

Start Date: 17/01/2012

Required Date: 24/01/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	682.0000	0.8269	14.70044			

MNEO60S 063

NEOPRENE SHEET 0.063

**

20,
B12-a-1

Location

Loc Qty

Loc Code

MAT052

682

119130

3

119777

279

119792

400

119777

24

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	78964
Description: Gasket		Part Number:	D3536-13
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	32.90	✓		T Bul	
29.40	+/-0.030	29.40	✓		T	
27.40	+/-0.030	27.40	✓		T	
23.90	+/-0.030	23.90	✓		T	
18.98	+/-0.030	18.98	✓		T	
14.07	+/-0.030	14.07	✓		T	
9.15	+/-0.030	9.15	✓		T	
5.65	+/-0.030	5.65	✓		T	
3.90	+/-0.030	3.90	✓		T	
8.00	+/-0.030	8.00	✓		T	
14.00	+/-0.030	14.00	✓		T	
20.00	+/-0.030	20.00	✓		T	
1.89	+/-0.030	1.89	✓		V Bul	
0.30	+/-0.030	0.304	✓		V	
0.30	+/-0.030	0.302	✓		V	
Ø0.19	+0.005/-0.001	0.191	✓		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 12-2-1	Date: 12/2/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	BE

W/O:		WORK ORDER CHANGES					
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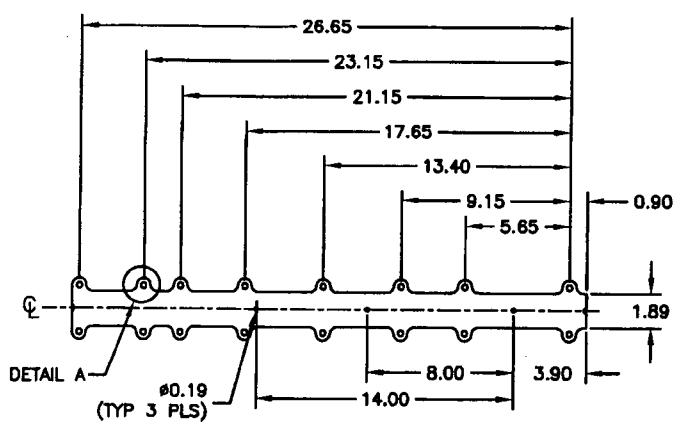
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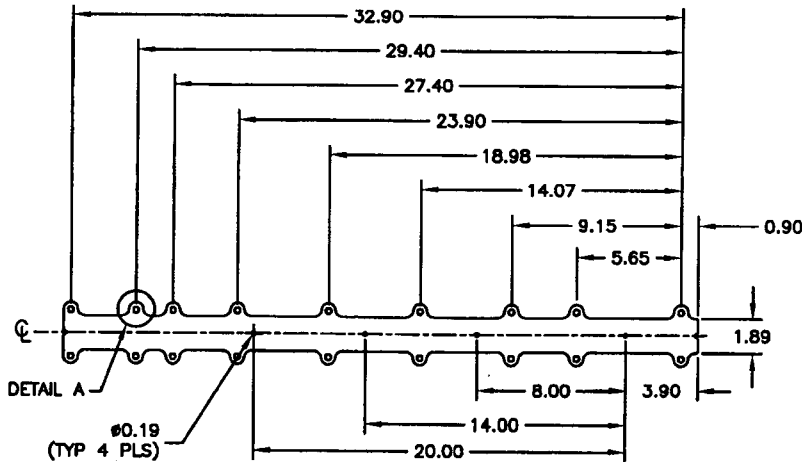
RELEASED
09-02-12-11

SHOECOAT
REPLACEMENT
DRAWING
UNCOVERED BY
SUBJECT TO
WELDER
WORK CENTER
NO. 78964 M.L.J
12/01/17

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 1 OF 6
				SCALE
A	06.10.25	NEW ISSUE		1:10



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

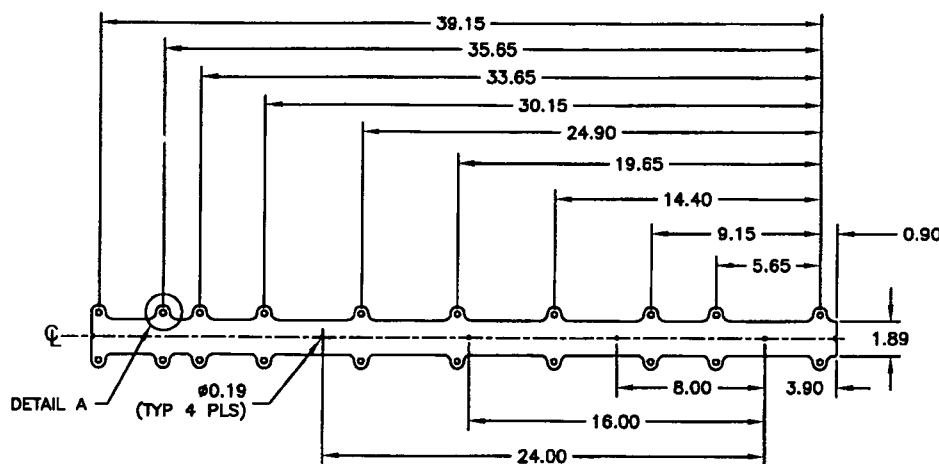
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

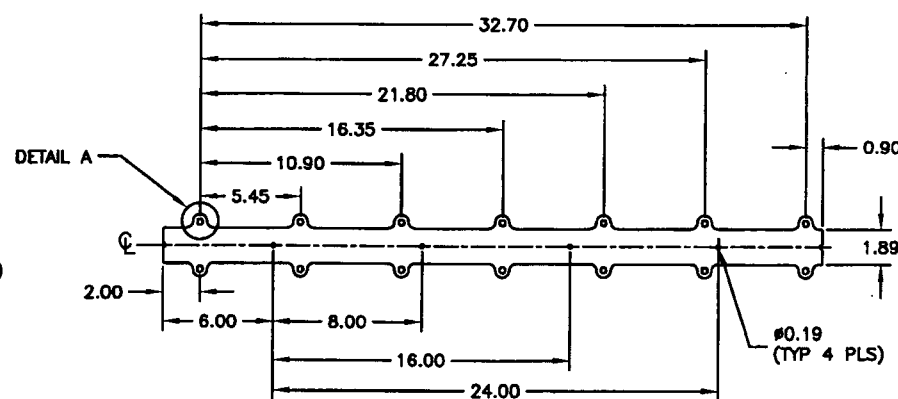
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DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.	REV. A
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	
DATE	06.10.25	TITLE	D3536	GASKET	SHEET 2 OF 6
					SCALE 1:10

RELEASED
070212



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

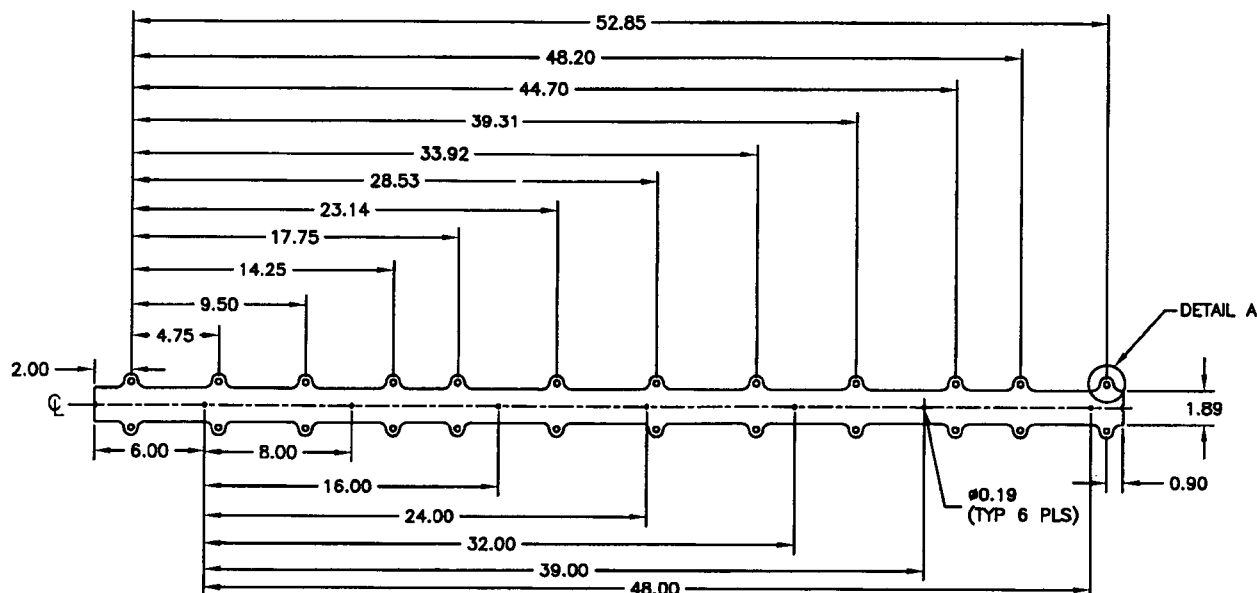
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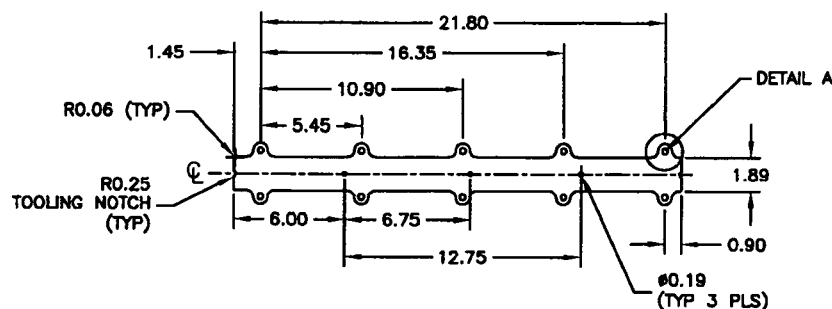
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CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	SHEET 3 OF 6
	SCALE 1:10	

70964

RELEASED
07-02-12



D3536-23 GASKET



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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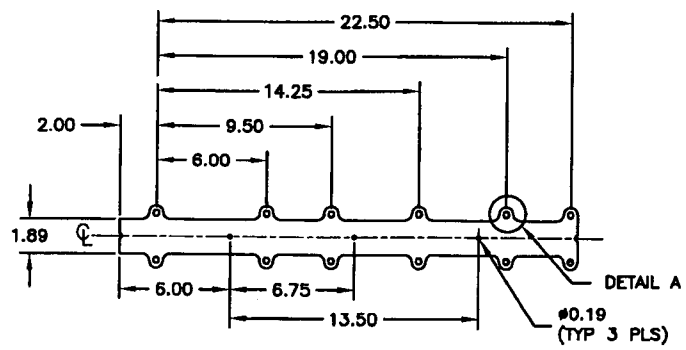
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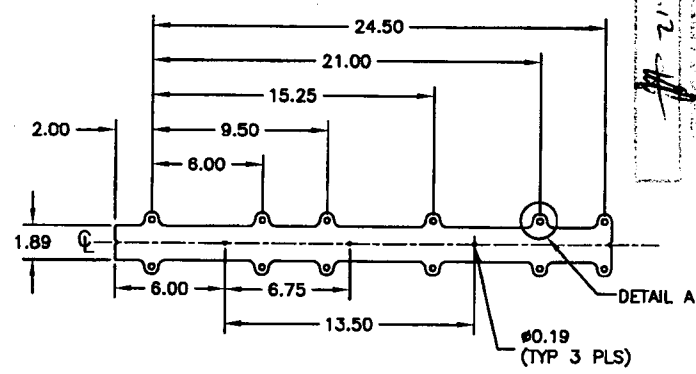
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 4 OF 6
				SCALE
				1:10

78964

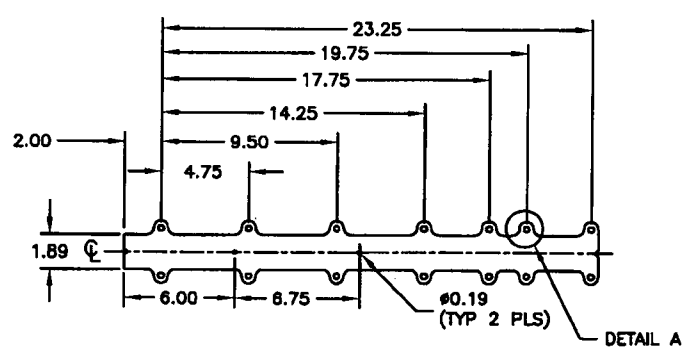
07.02.12



D3536-31 GASKET



D3536-33 GASKET



D3536-35 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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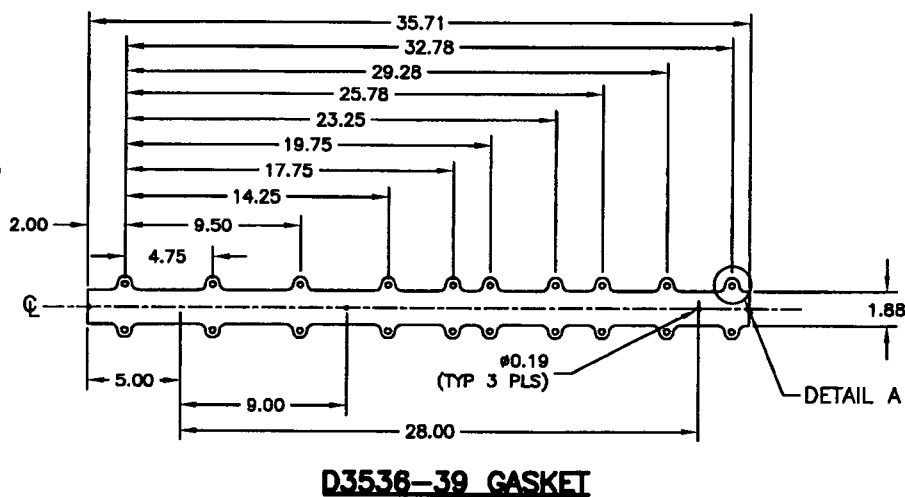
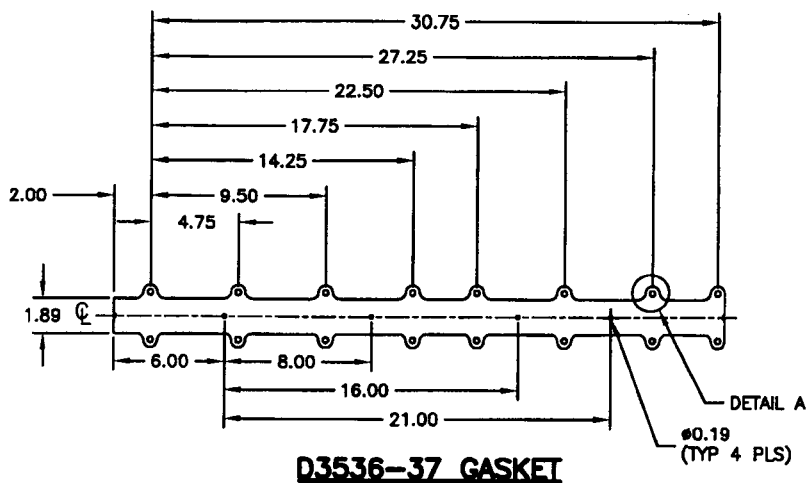
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DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	SHEET 5 OF 6
	SCALE 1:10	

07.02.12
07.02.12
07.02.12



NOTES

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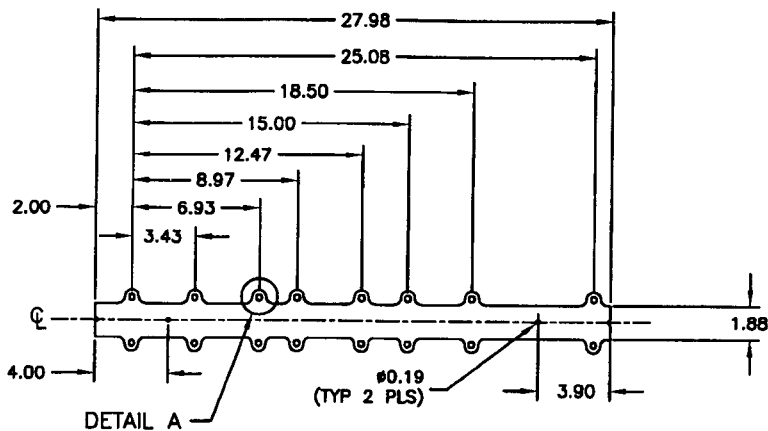
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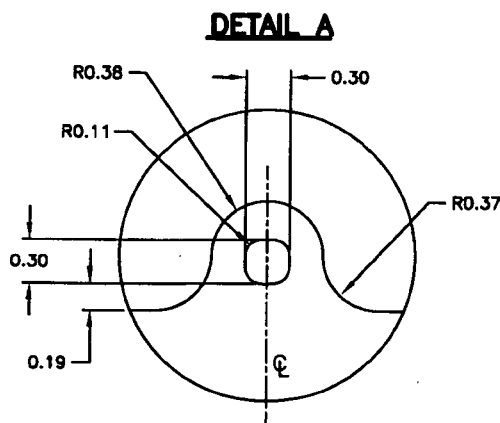
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DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	AM	APPROVED	AM	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 6 OF 6
				SCALE 1:10

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789164



D3536-41 GASKET



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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